

235/487.800

200710" FEET44001

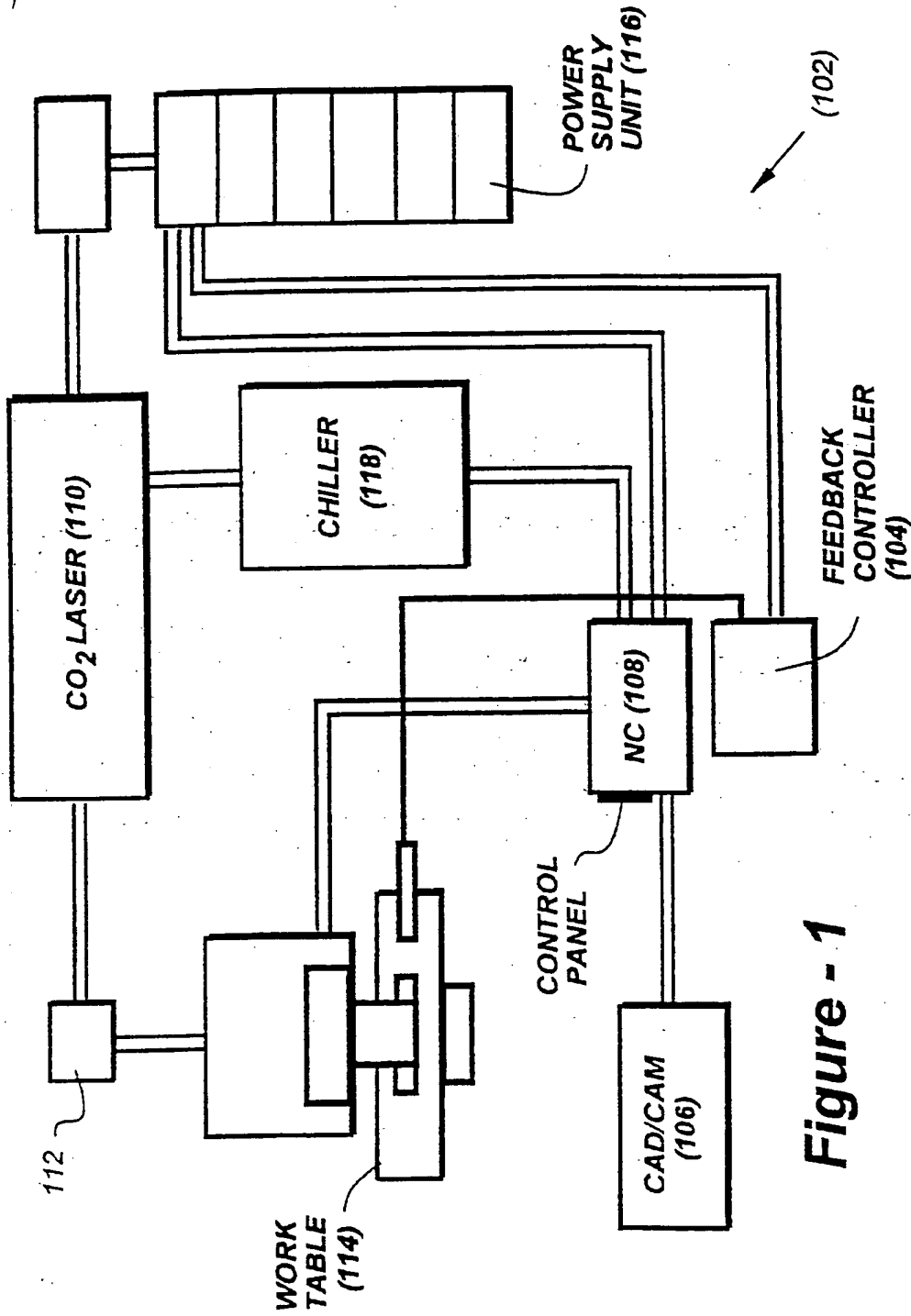
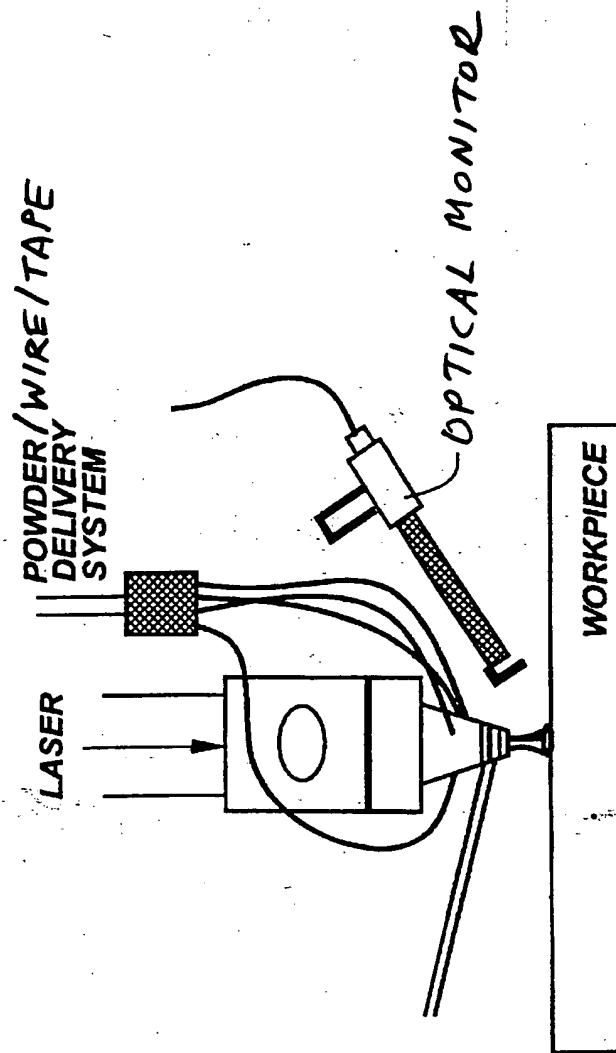


Figure - 1

Figure - 2



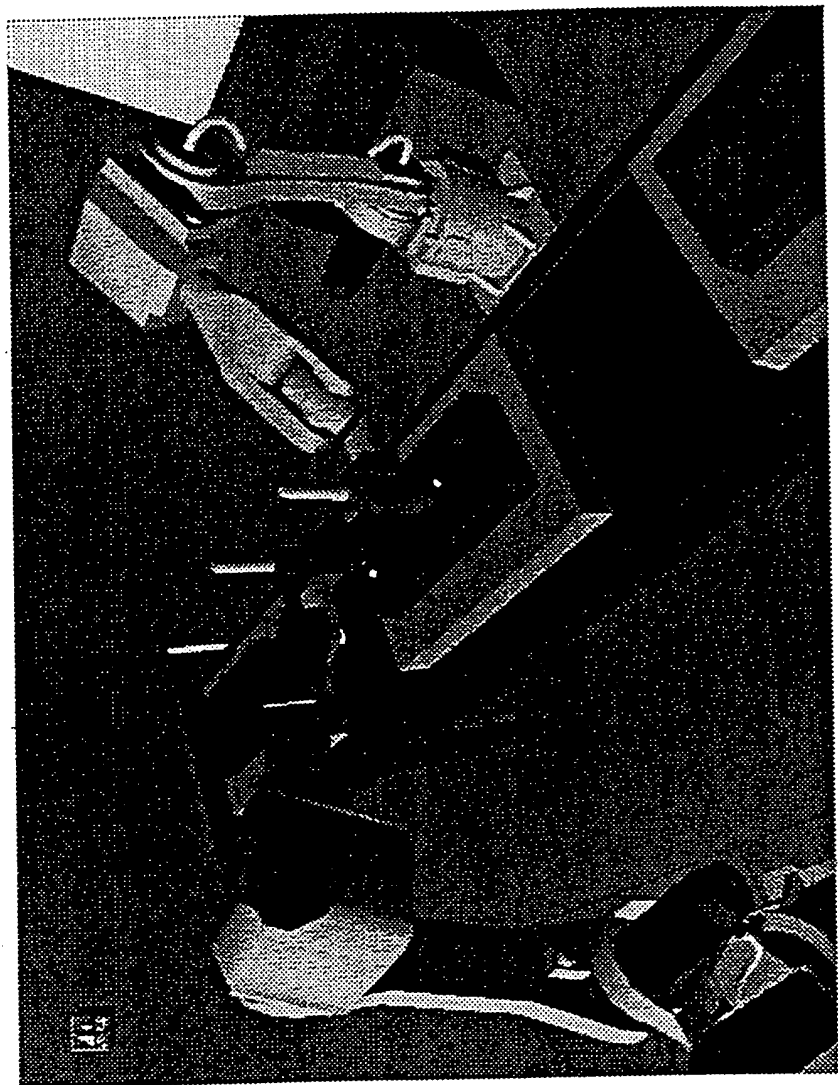


Figure 3. Robotic embodiment of DMD

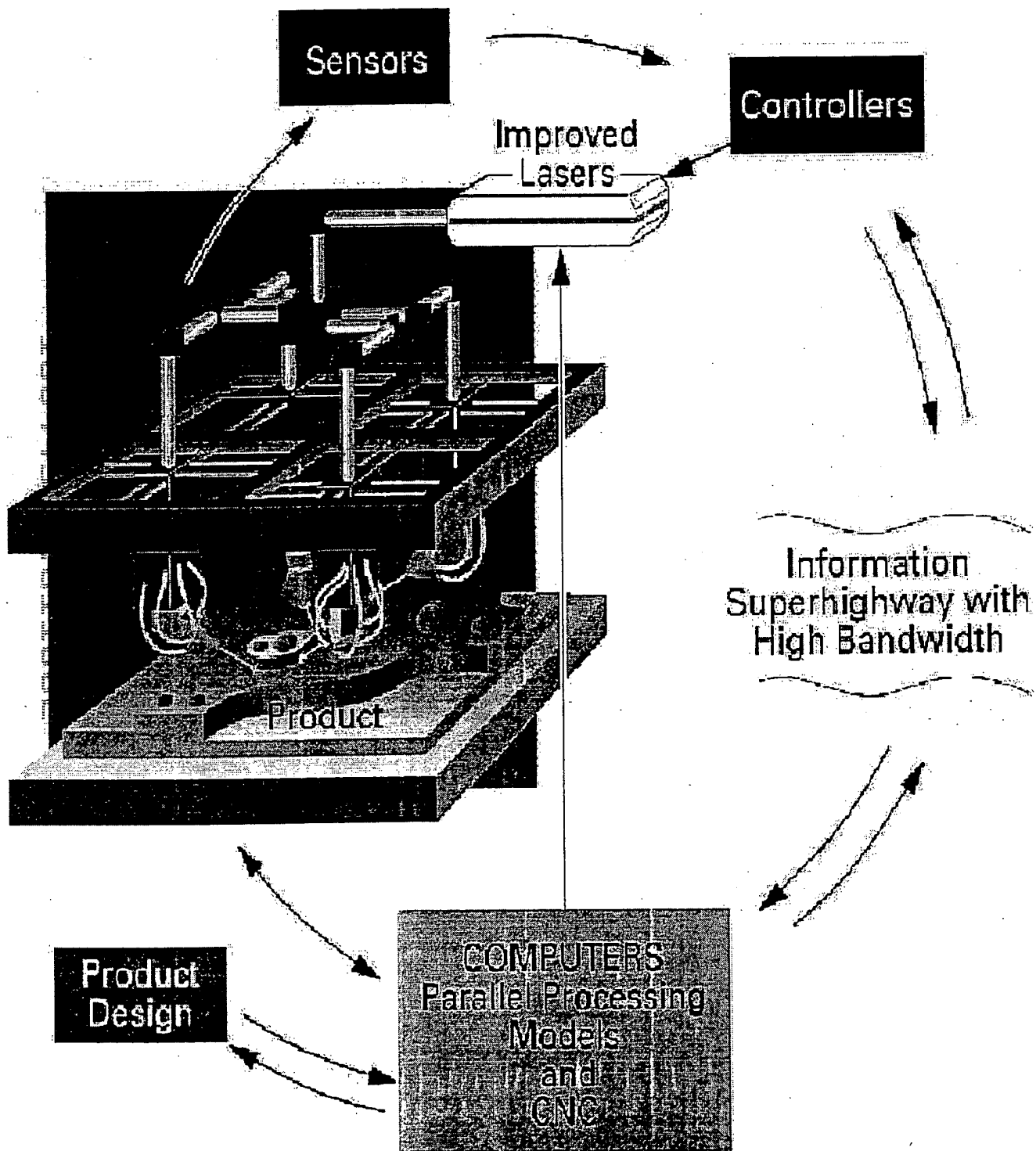


FIGURE 4

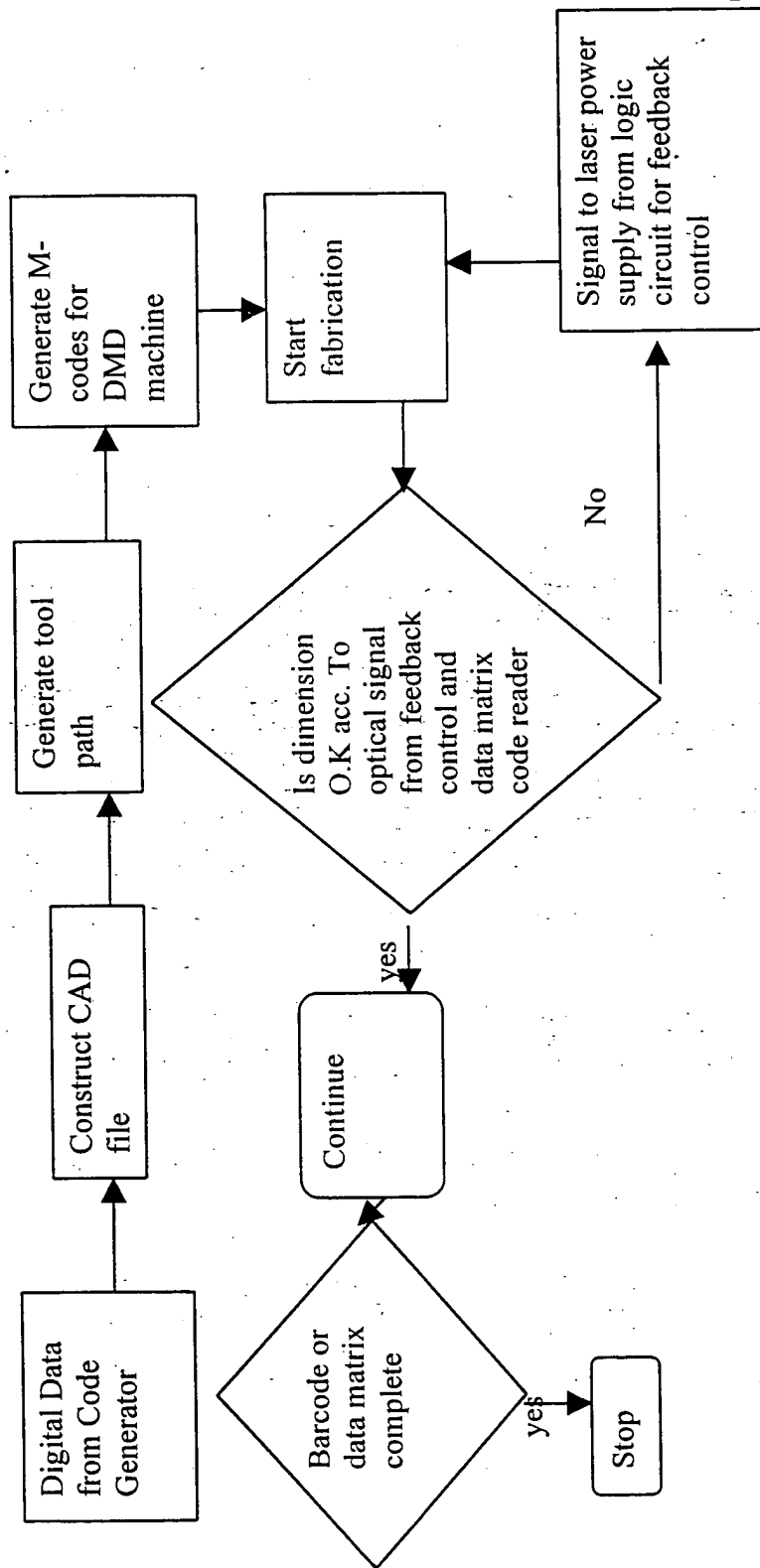


FIGURE 5

10044331 011000

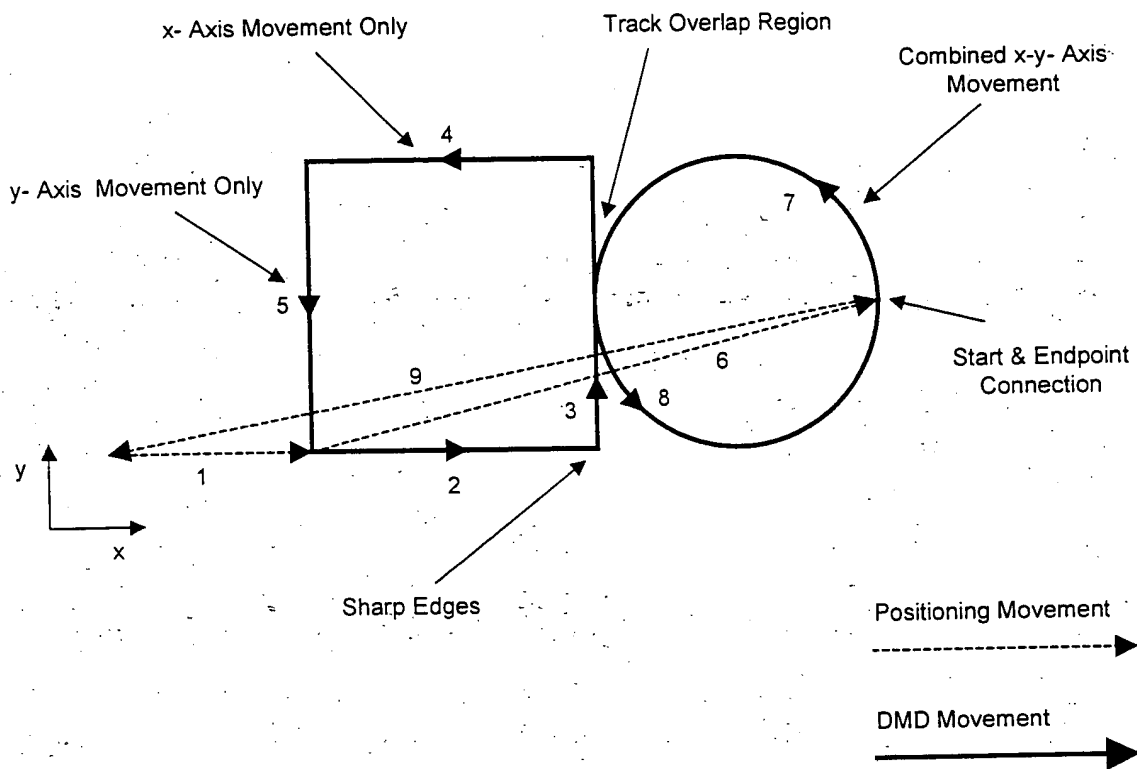
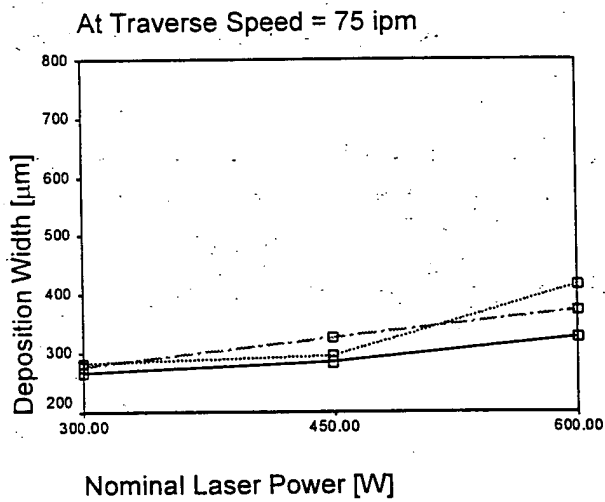
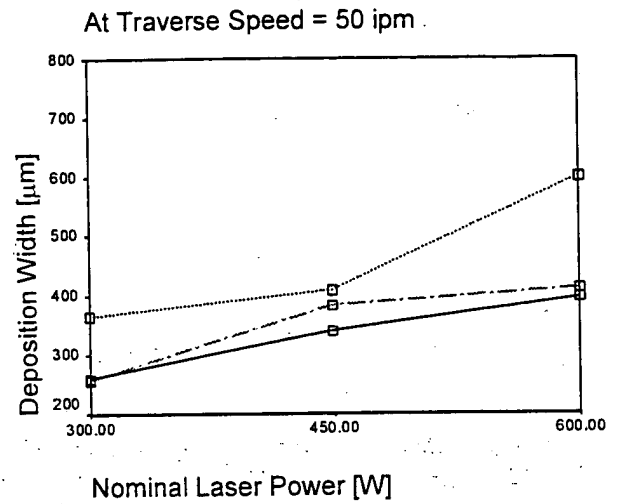
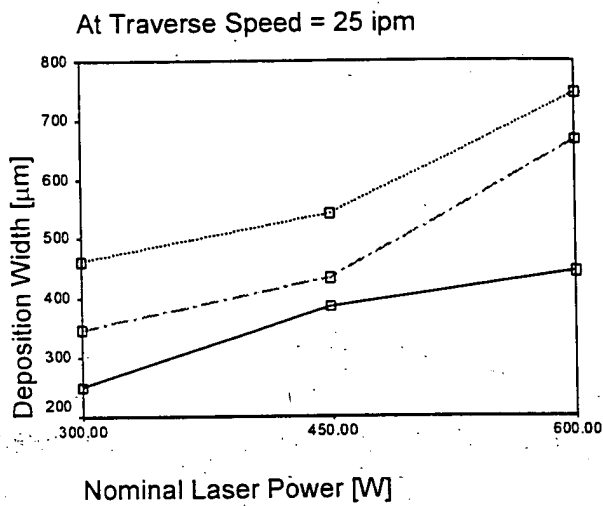


FIGURE 6

20070707



Powder Feed Rate [g/30s]

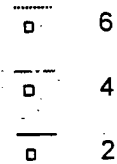
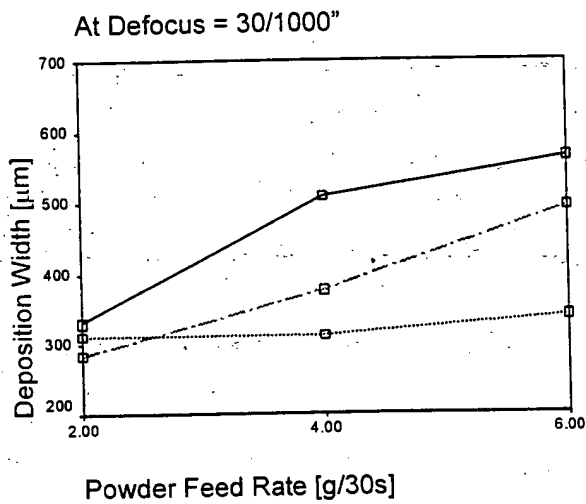
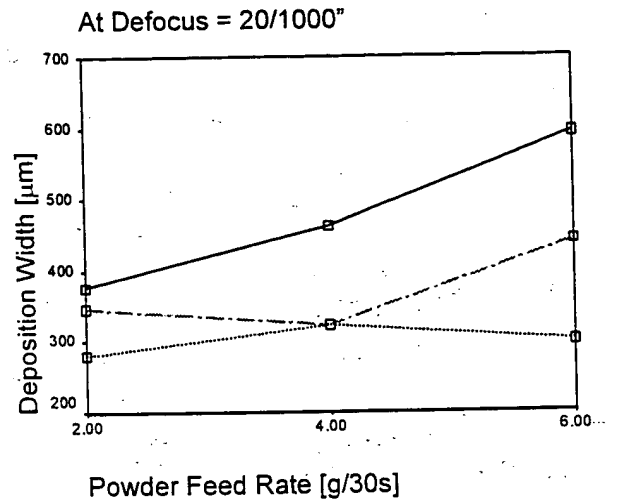
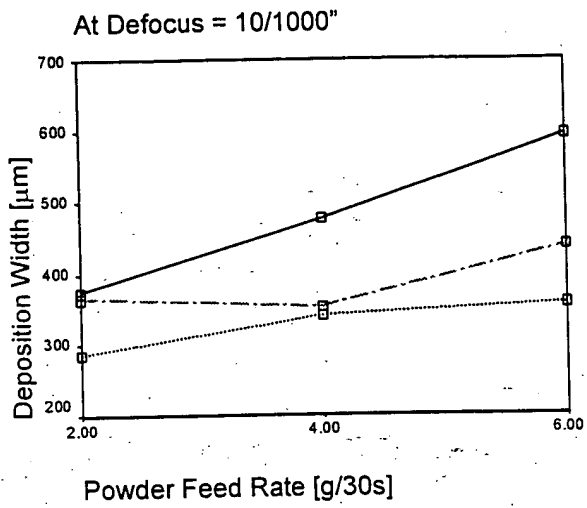


FIGURE 7

200FTD"FEET400T

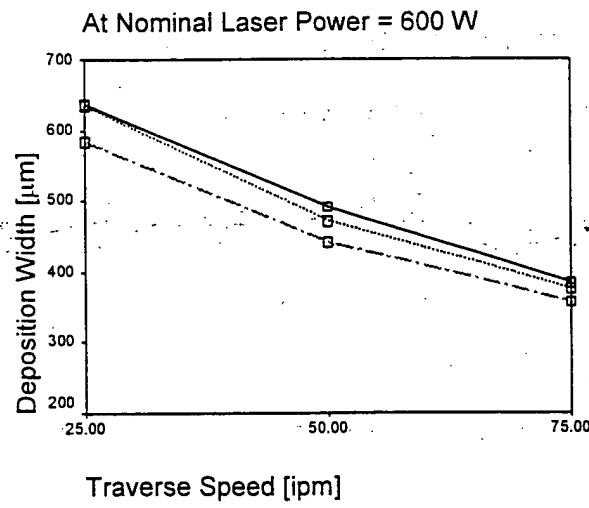
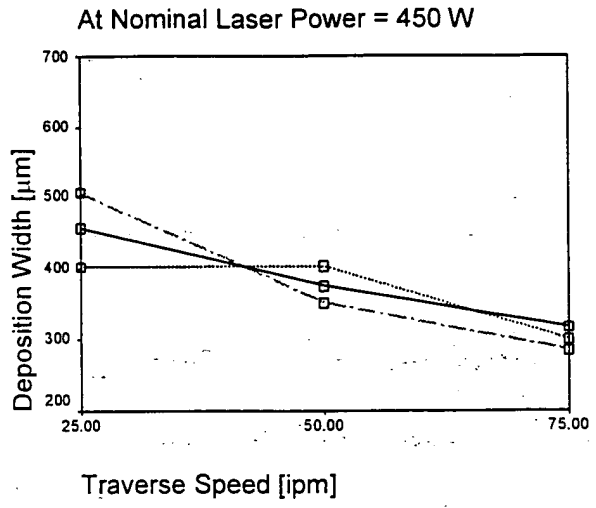
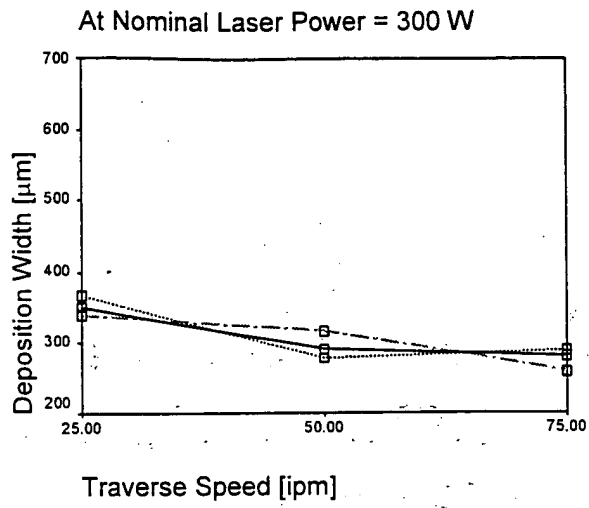


Traverse Speed [ipm]

- 75
- - - 50
- 25

FIGURE 8

2007-07-10 14:00:00

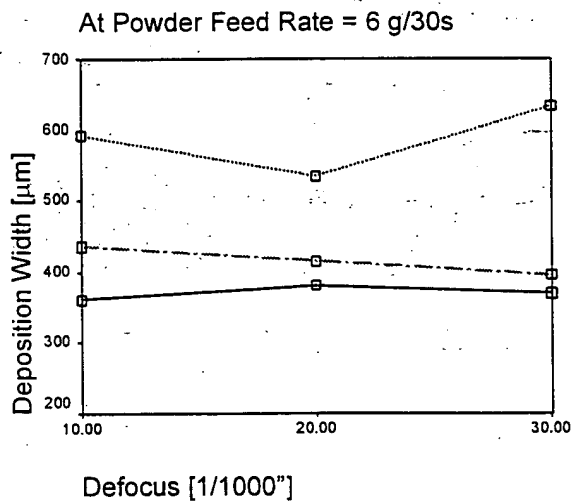
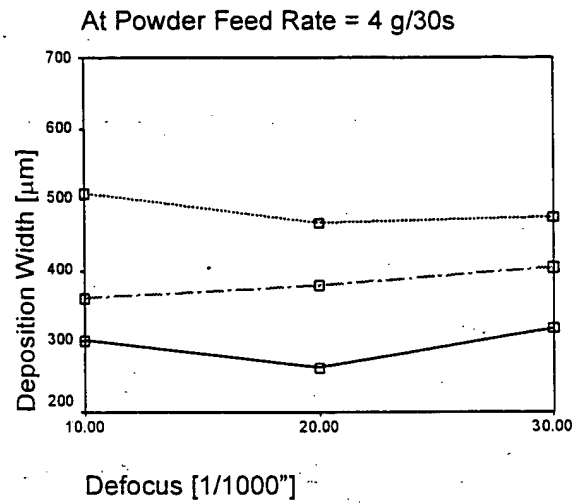
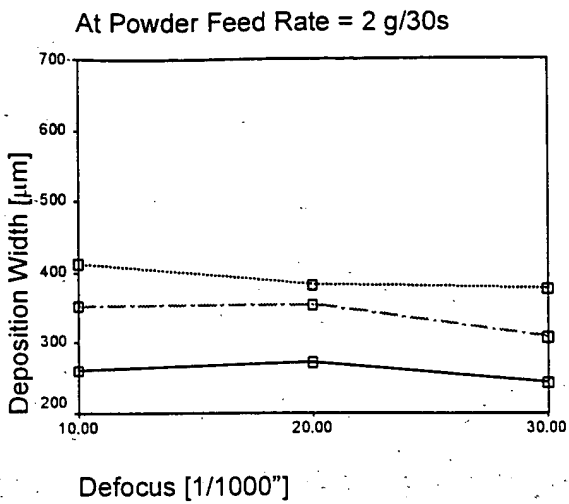


Defocus [1/1000"]

- 30
- 20
- 10

FIGURE 9

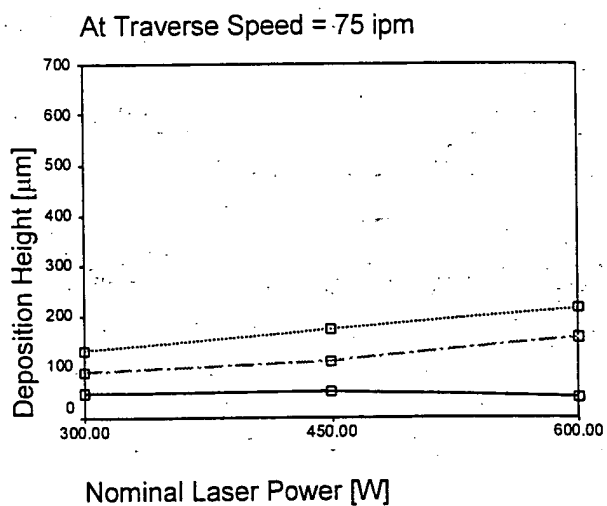
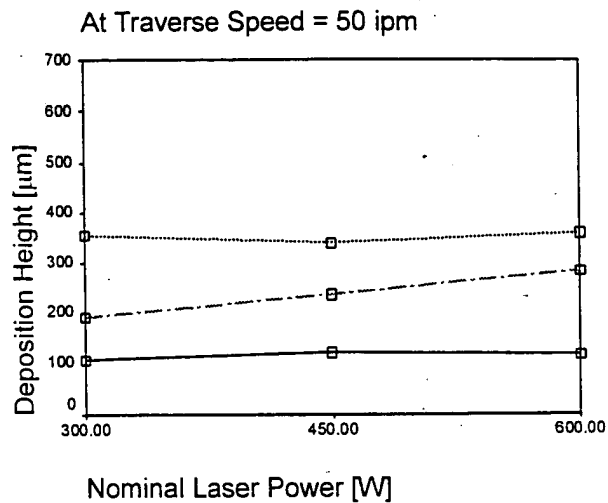
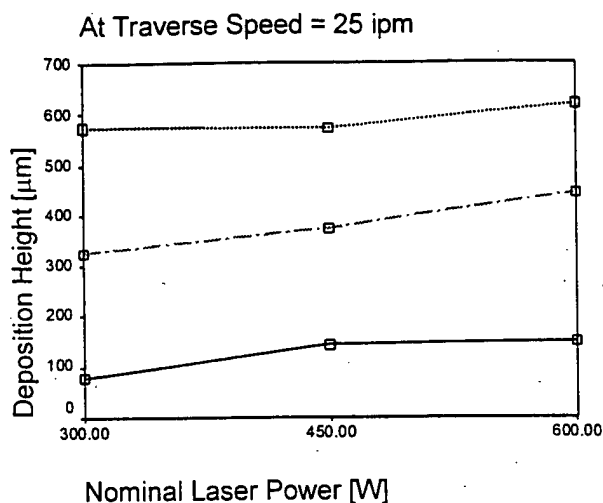
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Nominal Laser Power [W]

- 600
- 450
- 300

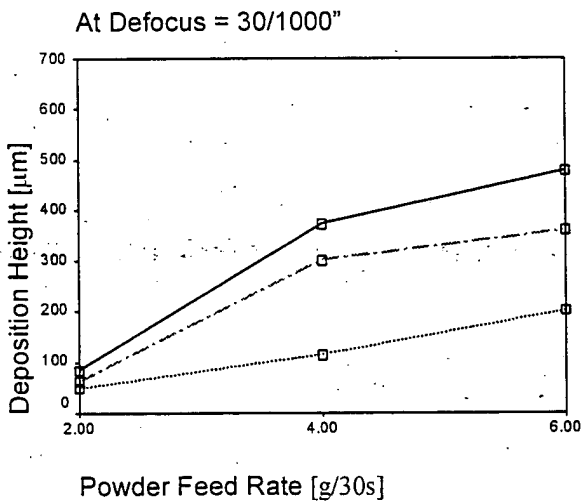
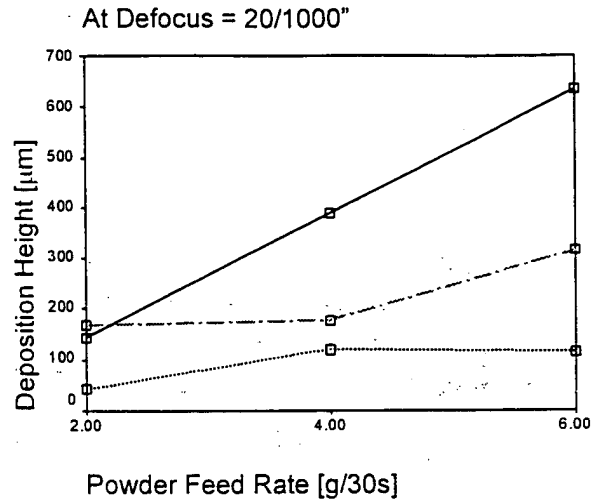
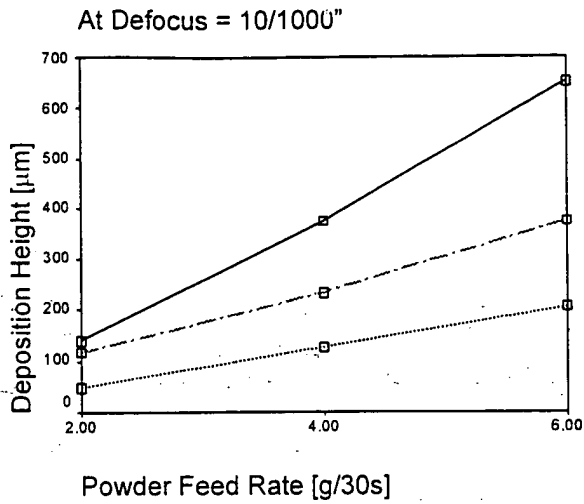
FIGURE 10



Powder Feed Rate

- 6.00
- 4.00
- 2.00

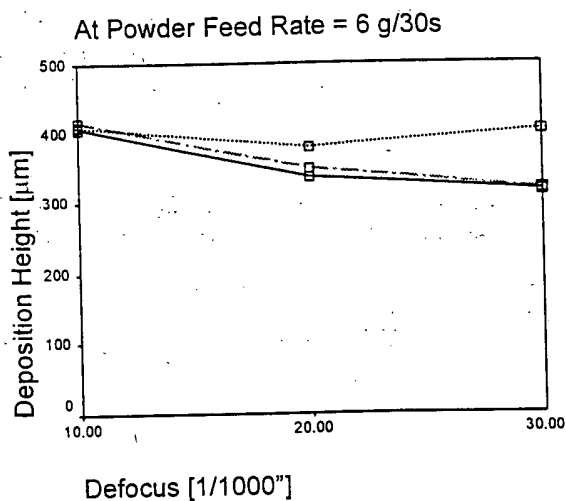
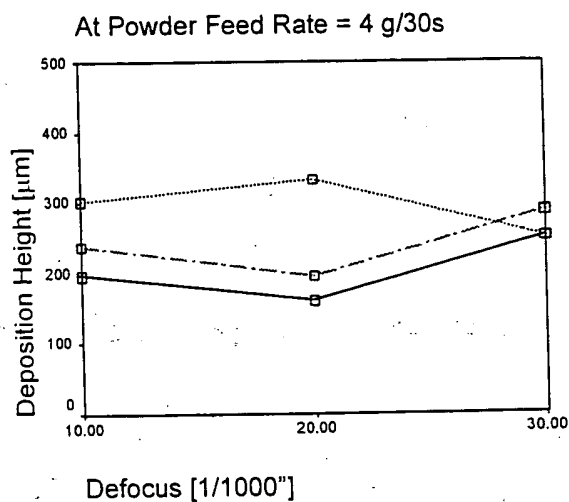
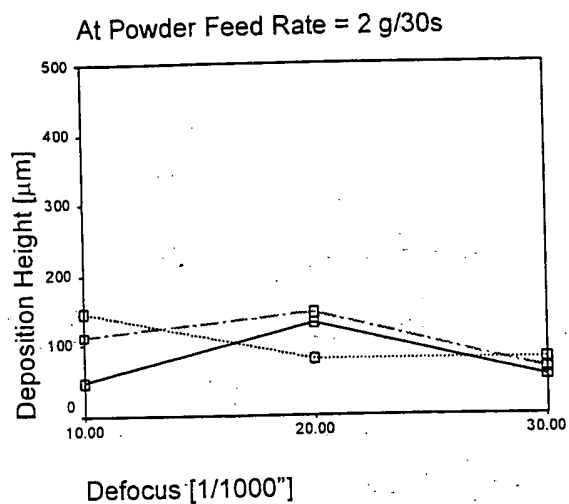
FIGURE 11



Traverse Speed [ipm]

- 75
- 50
- 25

FIGURE 12

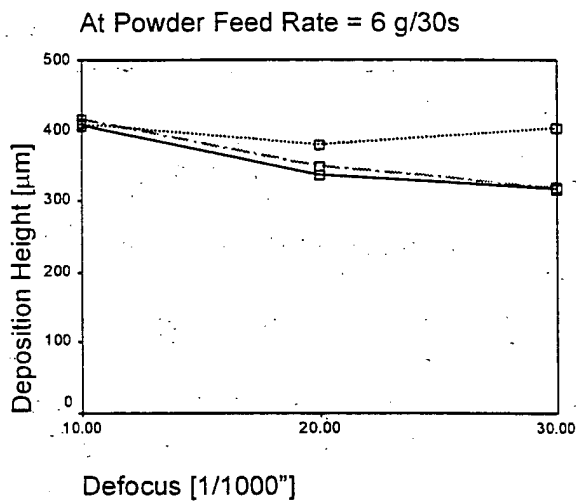
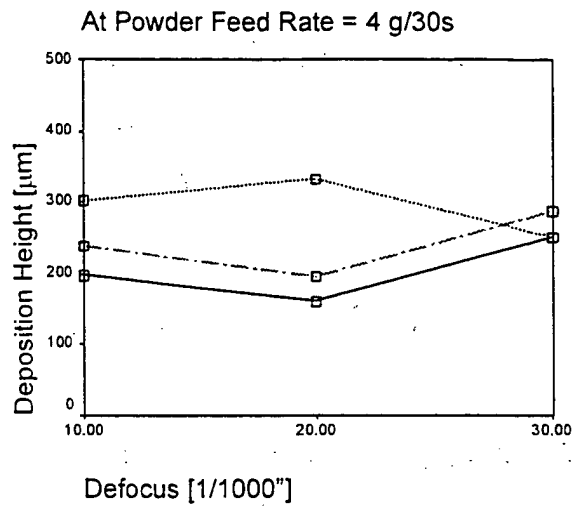
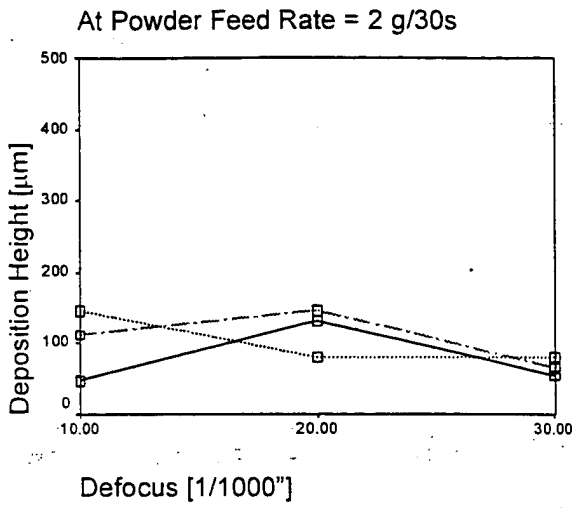


Nominal Laser Power [W]

- 600
- 450
- 300

FIGURE 13

2007-07-10 14:00



Nominal Laser Power [W]

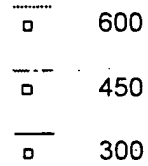


FIGURE 14